

Date: Monday, 7/16/2007 2:48:15 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG	
Job Number	: 33568				
Estimate Number	: 10008				
P.O. Number	: N/A		Part Number	: D2591	
This Issue	: 7/16/2007	S.O. No. : N/A	Drawing Number	: D2591 REV D	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: D	
Previous Run	: 33086		Material	: N/A	
Written By			Due Date	: 7/30/2007	
Checked & Approved By			Qty:	17	
Comment	: Est Rev:I Removed from 9 Digit 05-10-25 JLM		Um:	Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010B0750X02500	ASTM A21 Steel .75"x2.5"
		Comment: Qty.: 0.2340 f(s)/Unit Total : 9.3600 f(s) ASTM A36 Steel bar 2.50" x 0.75" thick(M1010-B0.750X02.500) Batch: M104X88 x17 prs
2.0	BAND SAW	BAND SAW
		Comment: BAND SAW Cut blanks: 2.700" long
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 issue P/O 4830 meter
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA 039 and Dwg D2591 2- Deburr if required
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE receive + inspect for transit damage.
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
5.0	QC5	SECOND CHECK A-11-13
		Comment: SECOND CHECK inspect levels PTC last page.
6.0	PACKAGING 1	PACKAGING RESOURCE #1 02-11-13 17
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: welding

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Job Number: 33568		Part Number: D2591
Job Number:		
Seq. #:	Machine Or Operation:	Description :
7.0	QC21	FINAL INSPECTION/W/O RELEASE
		
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion		

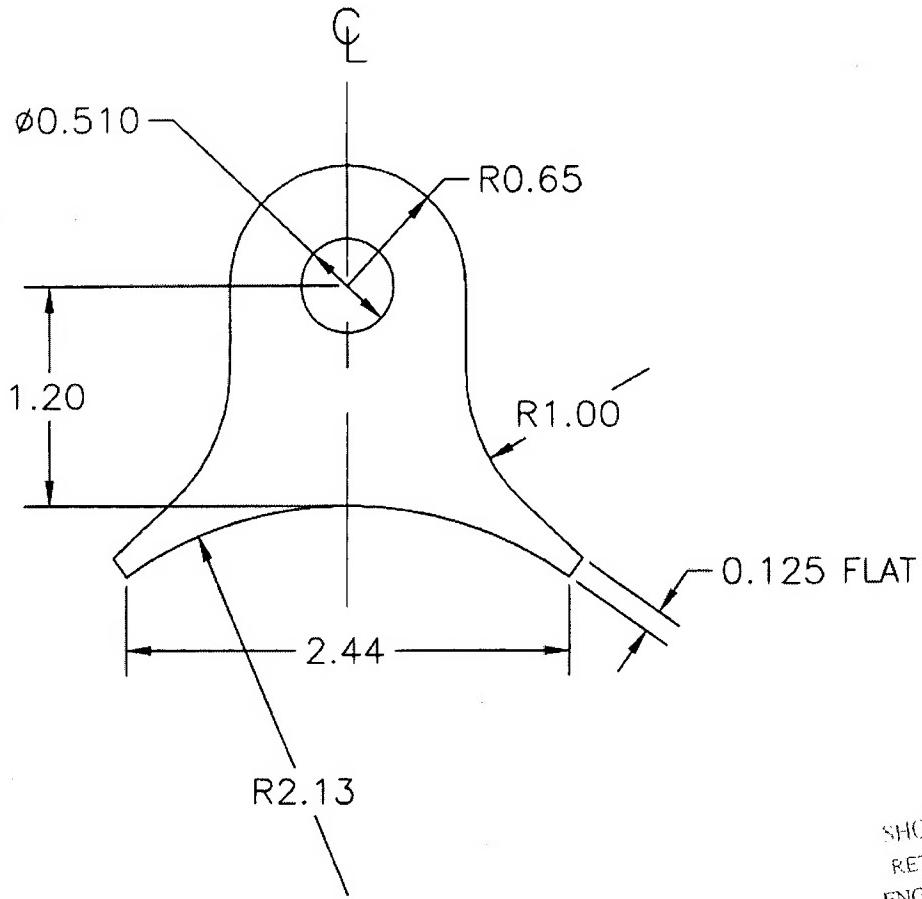
7/16/13
K St. 13



DO COPY
DATE

DESIGN <i>DNY</i>	DRAWN BY <i>DNY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>KE</i>	APPROVED <i>BW</i>	DRAWING NO. D2591
DATE 98.01.21		REV. D SHEET 1 OF 1
		TITLE GHW LUG
		SCALE 1:1
A	96:09:16	NEW ISSUE
B	97:06:17	RE-DESIGN TO FLAT BOTTOM
C	97.12.12	RE-DESIGN TO RADIUS BOTTOM
D	98.01.21	0.125 FLAT WAS 0.067 FLAT

RELEASED
98.01.21 DS



BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: ASTM A36 STEEL 0.50 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

PART IS SYMMETRIC ABOUT CENTER-LINE

ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33568

11/05/2007 08:32

1-613-678-3956

METEC & MAST

PAGE 02/02

**CERTIFICATE OF CONFORMITY****SOLD TO:**

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
85	D2591	Lug B34829	4830
17	D2591	Lug B33568	4830

MATERIAL: supplied by DART M1010B07540X02500 B105801

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Shig Walz".

A handwritten signature in black ink, appearing to read "J".

Vankleek Hill, November 2, 2007

11/05/2007 08:32 1-613-678-3956

METEC & MAST

PAGE 01/02



20 Terry Fox Drive
 Vankeek Hill, Ontario K0B 1R0
 Tel: (613) 678-3957
 Fax: (613) 678-3956

Delivery Slip No.: 16227
Date: Nov 02, 2007
Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 4830	Sold By: Walz, Christian D.
Shipped By: our truck	Ship Date: Oct 31, 2007

Description	Unit	Ordered quantity	Shipped quantity	Backordered quantity
D2591 Lug in steel B34829 D2591 Lug in steel B33568	Each Each	90 17	85 17	
Material supplied by DART M1010B0754DX02500 B105801				

Please note that 5 pieces were scrapped during machining.

A handwritten signature in black ink, appearing to be a stylized 'J' or a similar character, is placed here.

Received by _____

Thank you for your order!

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DD Date: 07/11/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/13	3.0	Sparts scrapped Meter. Ø 510 were too big.	<u>Q</u> <u>QS1042</u>	Scrap & destroy the N.C. items returned.	<u>DD</u> <u>07/11/13</u>	<u>DD</u> <u>07/11/13</u>	<u>Q</u> <u>QS1042</u>	<u>DD</u> <u>07/11/13</u>

NOTE: Date & initial all entries